Rear Side Outer Panel

Replacement

1. Remove the related parts.
   - Rear bumper
   - Rear window
   - Quarter glass (coupe)
   - Trunk lid
   - Taillight
   - Rear pillar trim panel
   - Trunk side panel
   - Rear seat
   - Rear seat belt
   - Fuel fill pipe (left side only)

⚠ WARNING **Do not smoke while working near the fuel system. Keep open flame away from the fuel system. If necessary, remove the fuel tank and/or lines before welding nearby. Drain fuel into an approved container.**

2. Pull out and straighten the damaged area.

   NOTE: Carefully check the inner panel and trunk gutter for position and damage. Pull out the inner panel by cutting the outer if necessary.

   - Jack-up the body and place safety stands at the four designated support points.
   - Pull out the damaged rear side outer panel with the frame straightener, then pull out and straighten the rear pillar inner panel and rear wheelhouse.

   NOTE: Be careful not to pull out more than necessary.

   - After pulling, check the inner panel, rear panel and trunk gutter position using the body dimensional drawings (see section 6).

3. Peel off the undercoat.
   Heat the undercoat at the weld areas of the rear wheel house with a gas torch and peel off the undercoat with a metal spatula.

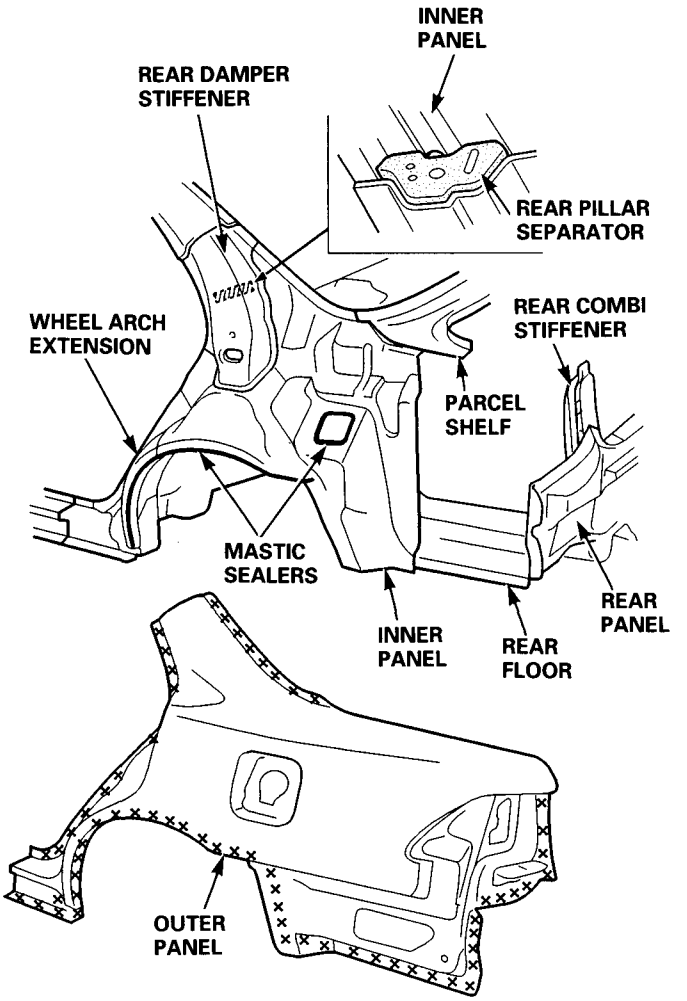
⚠ WARNING **Do not smoke while working near the fuel system. Keep open flame away from the fuel system. If necessary, remove the fuel tank and/or lines before welding nearby. Drain fuel into an approved container.**

4. Cut and pry off the rear side outer panel.
   - Cut at the center pillar (coupe), rear pillar and side sill with a handsaw.
   - Cut the panel from the body with a chisel, leaving the weld flange at the inner panel intact.

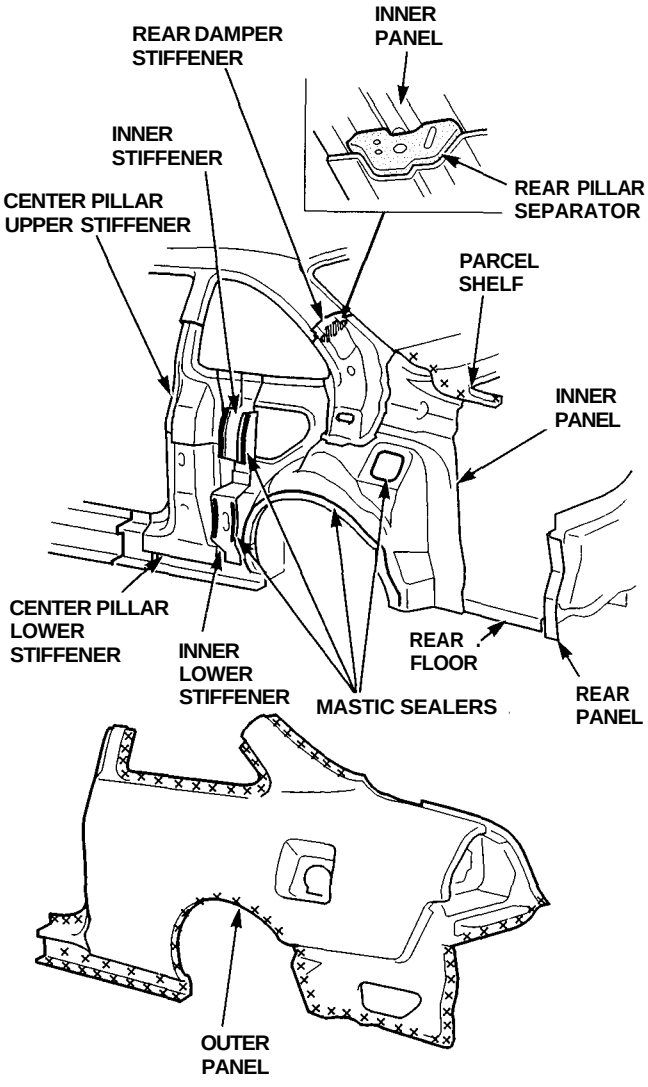
   NOTE: Do not cut or damage the inner panel, center pillar stiffener (coupe), rear damper stiffener, and rear pillar separator.

   - Cut at the side sill or wheel arch according to the extent of the damage.
   - Center punch around the spot weld imprints on the remaining flange.
   - Drill out the spot welds with the spot cutter.
   - Pry off the welded flange sections using a chisel.

Sedan:



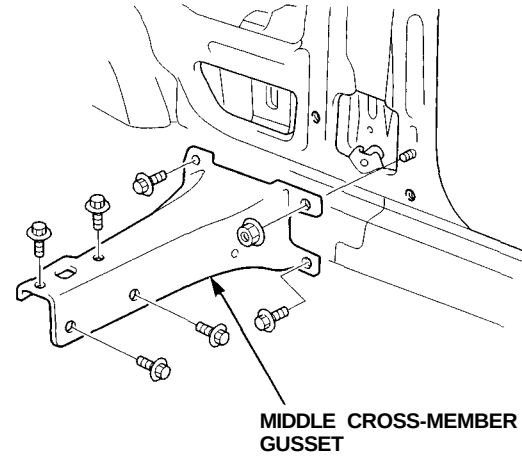
Coupe:



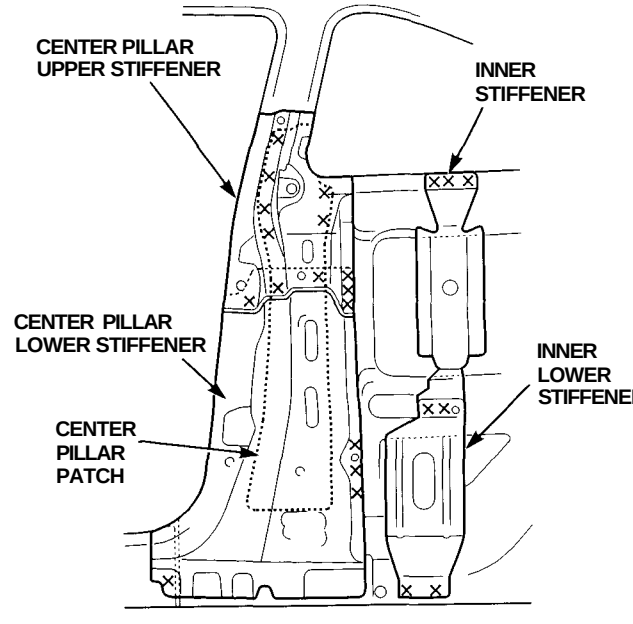
- Check the inner panel, center pillar lower and upper stiffeners, for position and damage.

5. Coupe: Remove the center pillar lower stiffener and inner stiffeners, if necessary.

-1 Remove the middle cross-member gusset.



-2 Cut and drill out the spot welds, and pry off the center pillar lower stiffener and center pillar patch as an assembly from the center pillar upper stiffener.



-3 Replace the inner stiffeners.

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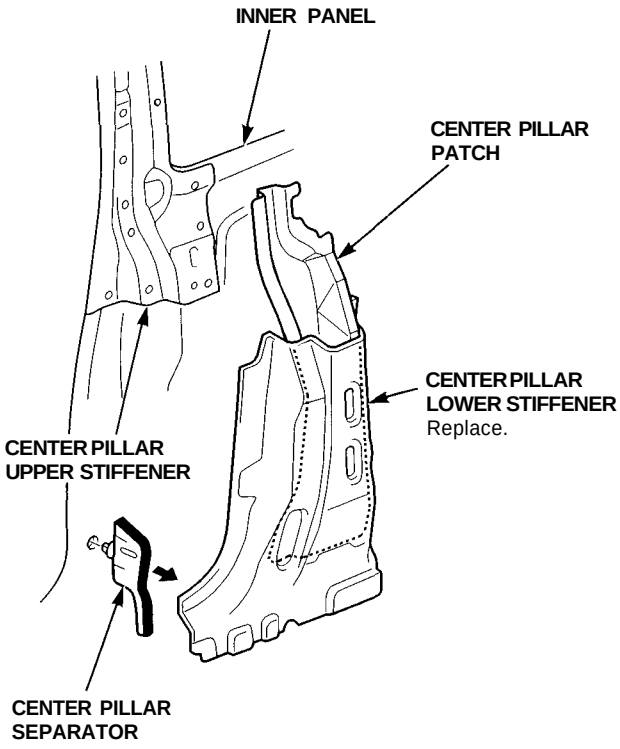
Rear Side Outer Panel

Replacement (cont'd)

-4 Remove the center pillar separator.



6. Straighten the inner panel and related parts.
   - Use a slide hammer to even out the damaged areas of the rear wheel arch.
   - Fill the holes drilled by MIG or gas welding.

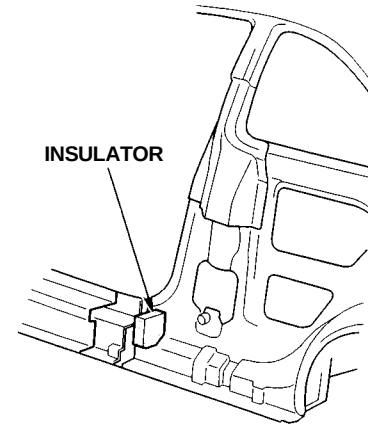
⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

   - Level and finish burrs, etc. with a disc sander.

⚠WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

7. Coupe: Glue the insulator to the inner panel at the center pillar separator mounted position.

   Insulator: P/N. 74416-SF1-000
   Adhesive: Cemedine 366 or equivalent

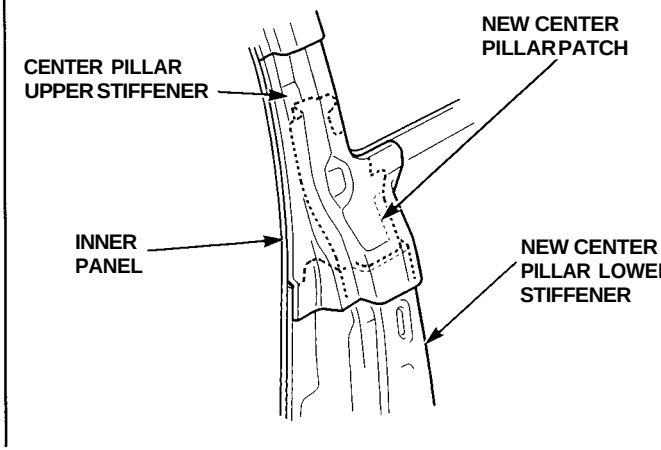


8. Coupe: Set the new center pillar lower stiffener and inner stiffeners.
   -1 Remove the new center pillar lower stiffener and center pillar patch as an assembly from the new center pillar upper stiffener.
   - Remove the undercoat from both sides of the weld flange with a sander to expose the steel plate.

   NOTE: Apply the spot sealer to the welding surface when spot welding.

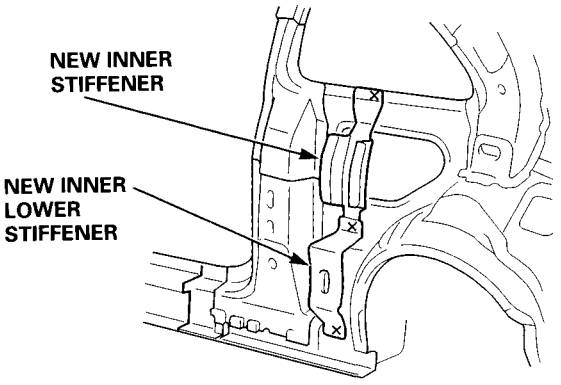
   -2 Insert the new center pillar patch and center pillar lower stiffener between the upper stiffener and inner panel, and install the middle cross-member gusset.

   - Check that the weld flange surfaces fit closely.



-3 Temporarily spot weld the inner stiffener.

WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**



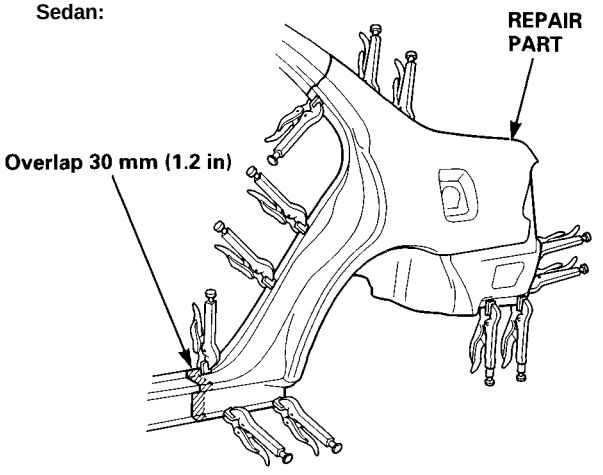
9. Cut and set the repair part.

- Cut the repair part cut so that the repair part overlaps the side sill by 30 mm (1.2 in).
- Apply body paint to the back of the repair part.
- See Paint Repair section.

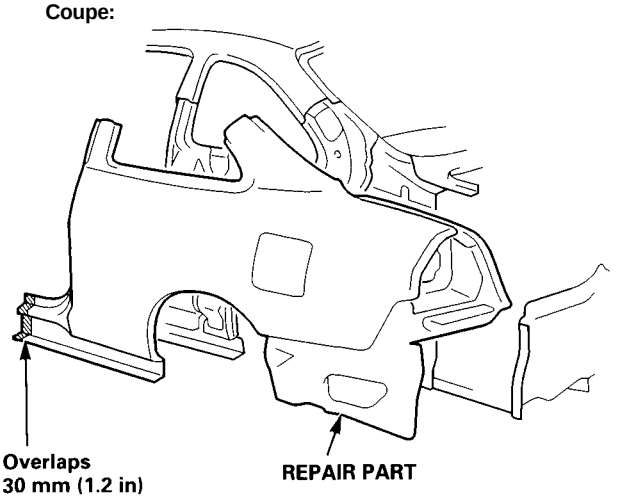
WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.**

Sedan:



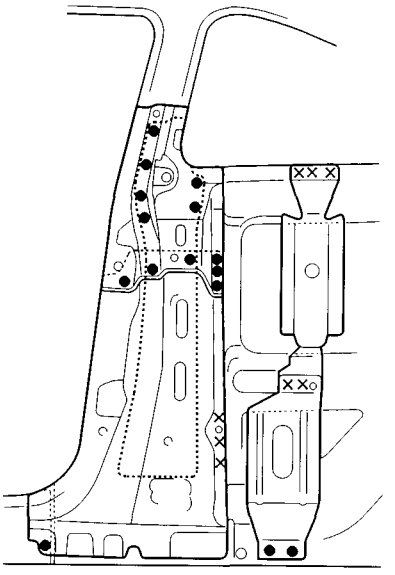
Coupe:



10. Clamp the repair part and check the position of the rear panel (sedan), center pillar lower stiffener (coupe), inner stiffeners (coupe) and repair part using the body dimensional drawings (see section 6).

11. Coupe: Remove the repair part, and weld the new center pillar lower stiffener and inner stiffeners.

WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**



(cont'd)

Rear Side Outer Panel

Replacement (cont'd)

12. Tack weld the repair part.
    - Remove the undercoat from both sides of the weld flange with a sander to expose the steel plate.

    NOTE: Apply the spot sealer to the welding surface when spot welding.

    Temporarily spot weld the panel at the clamped positions

    ⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves, and safety shoes.

13. Remove the vise-grips and check the alignment of the taillight (sedan), door, rear bumper and trunk lid.

    NOTE:
    - Check for flushness of the front fender, door, and the rear fender, taillight, rear bumper, and make sure the body lines flow smoothly.
    - Check the alignment of the rear window, quarter glass (coupe) and trunk lid.

14. Perform the main welding.

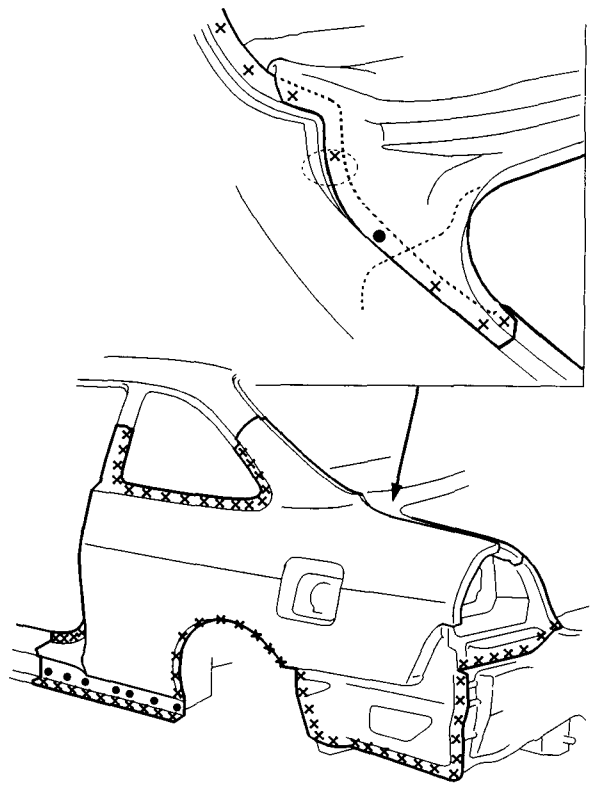
    ⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves, and safety shoes.

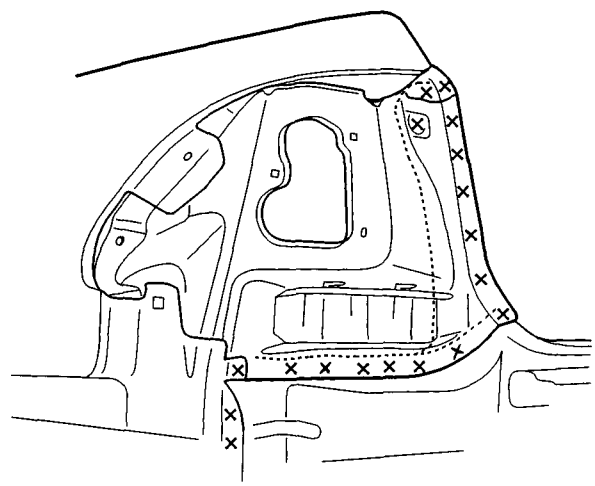
    - Make 20 % to 30 % more spot welds than there were holes drilled.

    NOTE: If there isn't room for spot welds, compensate by using MIG welds.

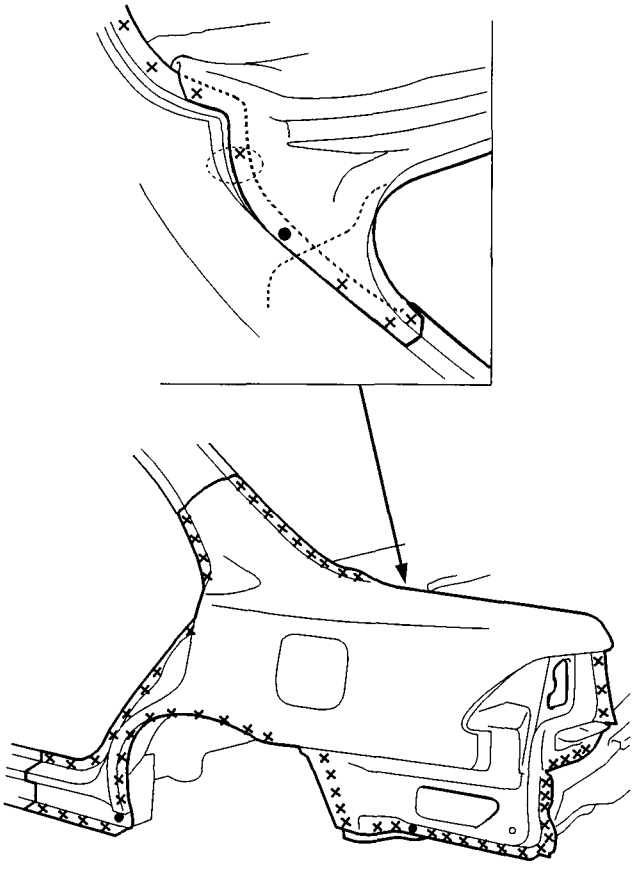
    - Make 5 mm (0.2 in) holes in the MIG weld hole with the repair part and the inner panel and center pillar stiffener with a MIG welder.
    - Weld the outer panel at the rear pillar and side sill with a MIG welder.

Sedan:





Coupe:



15. Finish the welded areas.
    - Level the MIG welded areas with a disc sander.

⚠WARNING **To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting, or grinding.**

    - Even out high areas with a hammer. Be careful not to deform them.
    - Even out the spot welded flange areas with a hammer and dolly.
    - Fill in deformations and level differences of the welded areas with solder or putty, then finish.

16. Apply the sealer (see section 5).
    Apply sealer to the fuel filler section, trunk lid opening joint and around the taillight area of the rear panel.

17. Apply paint. See Paint Repair section.

⚠WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

18. Apply the undercoat.
    Apply undercoat to the wheelhouse and apply anti-rust agent to the inside of the center pillar stiffener (coupe) and the outer panel (see section 7).

19. Install the related parts in the reverse order in which they were removed.

20. Inspect, check and clean.
    - Adjust the clearance with the door and trunk lid then adjust the level differences and fit.
      Check operation.
    - Test for leaks in the trunk and passenger compartments.
    - Check the quarter glass (coupe) and the rear window for water leaks.
    - Clean the trunk floor.